

Work Order ID 66065

Thursday, February 03, 2011 12:54:00 PM

Page 1

Item ID: D4318-011041
 Revision ID: PRELIM
 Item Name: Deck Assembly
 Start Date: 2/4/2011 Start Qty: 1.00
 Required Date: 2/11/2011 Req'd Qty: 1.00
 Reference:

Accept
 change parts number



Cust Item ID:
 Customer:

PRELIMINARY ISSUE

Approvals: Process Plan: MF Date: 11-02-03 Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start
 Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4318	PA2 PA3 11.02.14								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg (D4318-1) Dwg Rev: PA2 Prog Rev: PA2 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B 11-2-3



B 11-2-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Thursday, February 03, 2011 12:54:00 PM

Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00 - Inspector to P-2

QC

Memo

0.00 8 u l u z l o 7 00

Quality Control

130

0.00

Small Fab

Memo

0.00

Small Fab

- 1- Cut (2) D4318-3 see page 2
- 2- Cut (1) D4318-5 see page 2
- 3- Cut (2) D4318-7 see page 2
- 4- Cut (2) D4318-9 see page 2
- 5- Cut (2) D4318-11 see page 2
- 6- Use D4318-1 to transfer drill holes in angle as per dwg
- 7- C/sink holes in D4318-1 as per dwg →
- 7- Deburr holes if necessary

SPB 11/02/17
M. 11/02/16
11/02/16
11/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 3

Accept

DECLARATION OF INTEREST

Setup Start

Stop

Abstract

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

Tool ID

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

140

QC6- Inspect dimensions to drawing

0.00

HA 11.82.16

QC

Memo

0.00

Quality Control

- inspecters assembled angles on plate and rivets. - 8 worked to 1430 Dismantling

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

Chemical conversion coat on all angles and plate

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

Powder Coat all angles and plate

Start Time: 11:00 AM
Oven Temperature: 320 °F
Finish Time: 11:30 AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Thursday, February 03, 2011 12:54:00 PM

Accept

[illegible]**Setup Start**

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan

Accept Qty

Reject Qty

Reject
Number

**Insp.
Stamp**

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

180

0.00

Small Fab

Memo

0.00

Small Fab

Install angles and nut plates as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00 - inspection to P03

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 66065

Page 5


Thursday, February 03, 2011 12:54:00 PM

Item ID: D4318-011 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Deck Assembly
Start Date: 2/4/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 2/11/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

#66062

POSITIVE RECALL
POSITIVE RELEASE
EFFECTIVE DATE
RELEASED
AUTH 
DATE
DATE

MF
11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, February 03, 2011 12:53:55 PM

Work Order ID: 66065

Parent Item: D4318-011

Parent Item Name: Deck Assembly

Start Date: 2/4/2011


Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP REV:A 11.02.02 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125		Purchased	No			100	sf	92.0600	6.4162	6.753895			
													
6061-T6 .125 Sheet													

Location Loc Qty Loc Code

MAT	32	
116700	32	
MAT21	60.06	
113608	60.06	

M6061T6A.750W0.063"	Purchased	No
		

angle .750 x .750 x .063"		
---------------------------	--	--

MS20426AD3	Purchased	No
		
Rivet		

M116909

Location Loc Qty Loc Code

ST316	4641	
105055	1071	
116289	3570	

MS20426AD4	Purchased	No
		
Rivet		

Location Loc Qty Loc Code

ST317	2236	
12655	424	
18136	1812	

MS20426 AD 3-5

qty 12
B# 4179

S3 11/02/17

①

14.33'

116700

172.6526

S3 11/02/17

40 28

S3 11/02/17

40

41

S3 11/02/17

41

116733

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 12:53:55 PM

Page 2

Work Order ID: 66065

Parent Item: D4318-011

Parent Item Name: Deck Assembly

Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21075L4

Purchased

No

180

Each

71.0000

20

20



Nutplate



SO 11/02/17

Location

Loc Qty

Loc Code

ST303

21

115837

21

ST353

50

115908

50

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66065
Description: DECK ASSEMBLY		Part Number: D4318-1
Inspection Dwg: D4318-1, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .098	+ .004 - .001	.101	x		V B02	
φ .257	+ .006 - .001	.258	*		V	
φ .281	+ .006 - .001	.282	*		V	
φ .129	+ .005 - .001	.131	*		V	
7.03	± .030	7.032	*		V	
5.72	± .030	5.718	x		V	
1.88	± .030	1.877	*		V	
3.00	± .030	2.997	*		V	
4.63	± .030	4.623	*		V	
2.53	± .030	2.53	*		V	
1.13	± .030	1.128	x		V	
4.63	± .030	4.627	*		V	
3.00	± .030	3.000	*		V	
5.51	± .030	5.508	*		V	
5.00	± .030	5.001	*		V	
3.00	± .030	2.997	*		V	
1.31	± .030	1.313	*		V	
2.00	± .030	2.007	*		V	
3.56	± .030	3.563	*		V	
7.38	± .030	7.376	x		V	
5.50	± .030	5.501	*		V	
3.63	± .030	3.624	*		V	
5.62	± .030	5.617	*		V	

Measured by: RB
Date: 11-2-4

Audited by: S
Date: 11/02/02

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 66065
Description: DECK ASSEMBLY		Part Number: D4318-1
Inspection Dwg: D4318-1, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.69	±.030	2.69	X		V	
1.31	±.030	1.309	X		V	
84.00	±.030	84.00	X		T H201	
44.56	±.030	44.56	X		T "	
34.47	±.030	34.47	X		T	
36.94	±.030	36.94	X		T	
6.56	±.030	6.556	X		V 113-02	
1.25	±.030	1.247	X		V	
6.82	±.030	6.817	X		V	
1.00	±.030	1.00	X		V	
2.13	±.030	2.122	X		V	
7.25	±.030	7.249	X		V	
1.88	±.030	1.88	X		V	
11.00	±.030	11.00	X		T	
.44	±.030	.442	X		V	
28.55	±.030	28.55	X		T	
6.77	±.030	6.769	X		V	
50.13	±.030	50.13	X		T	
33.88	±.030	33.877	X		T	
25.13	±.030	25.126	X		T	
.38	±.030	.379	X		V	
2.28	±.030	2.285	X		V	
2.66	±.030	2.666	X		V	

Measured by: K3
Date: 11-24

Audited by: 8
Date: 11/02/02

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	66065
Description: D4318-041 Deck Assembly		Part Number:	D4318-041
Inspection Dwg: D4318	Rev: PA3	Page 1 of 1	

Page # 2

X

Prototype

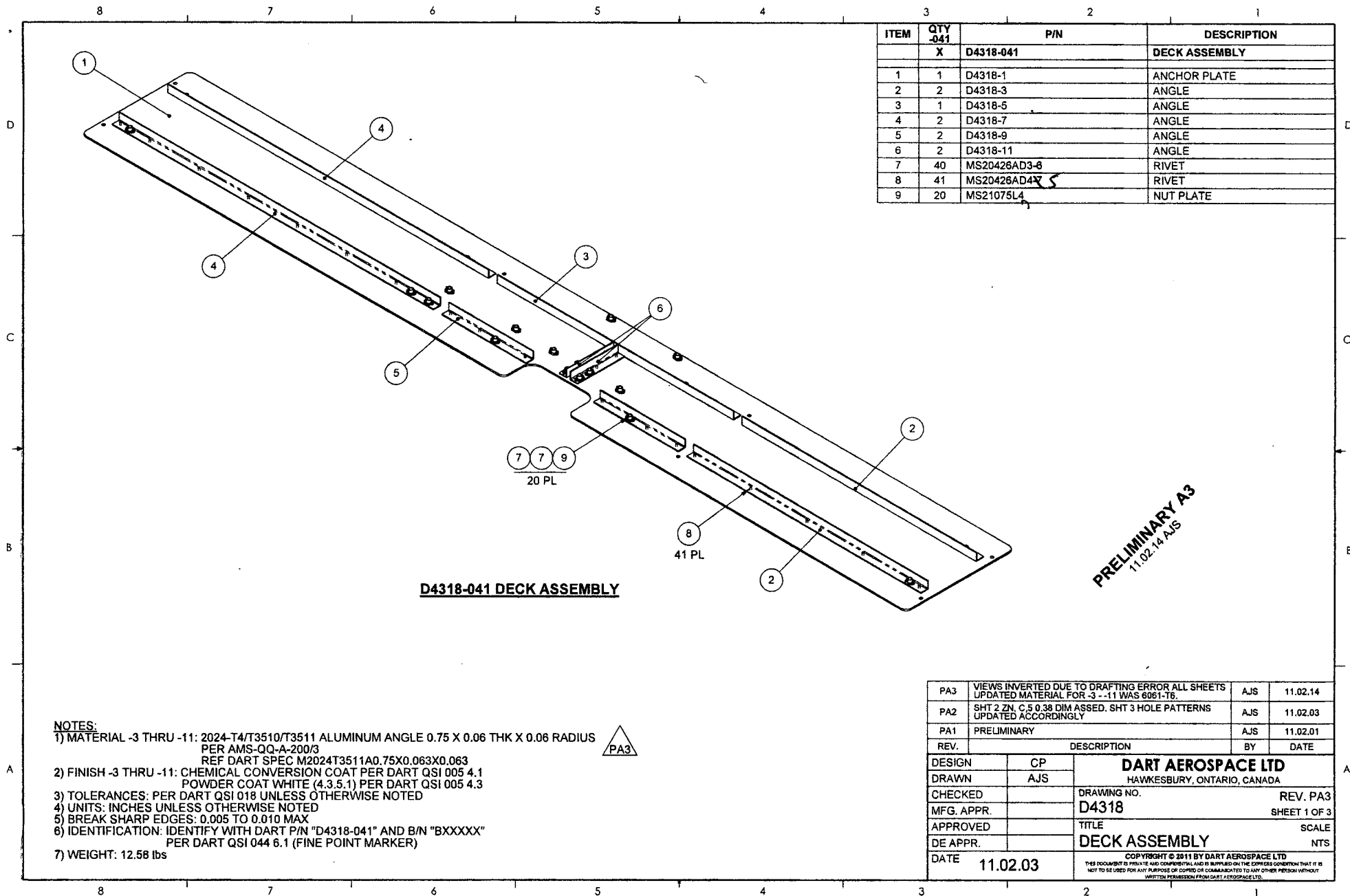
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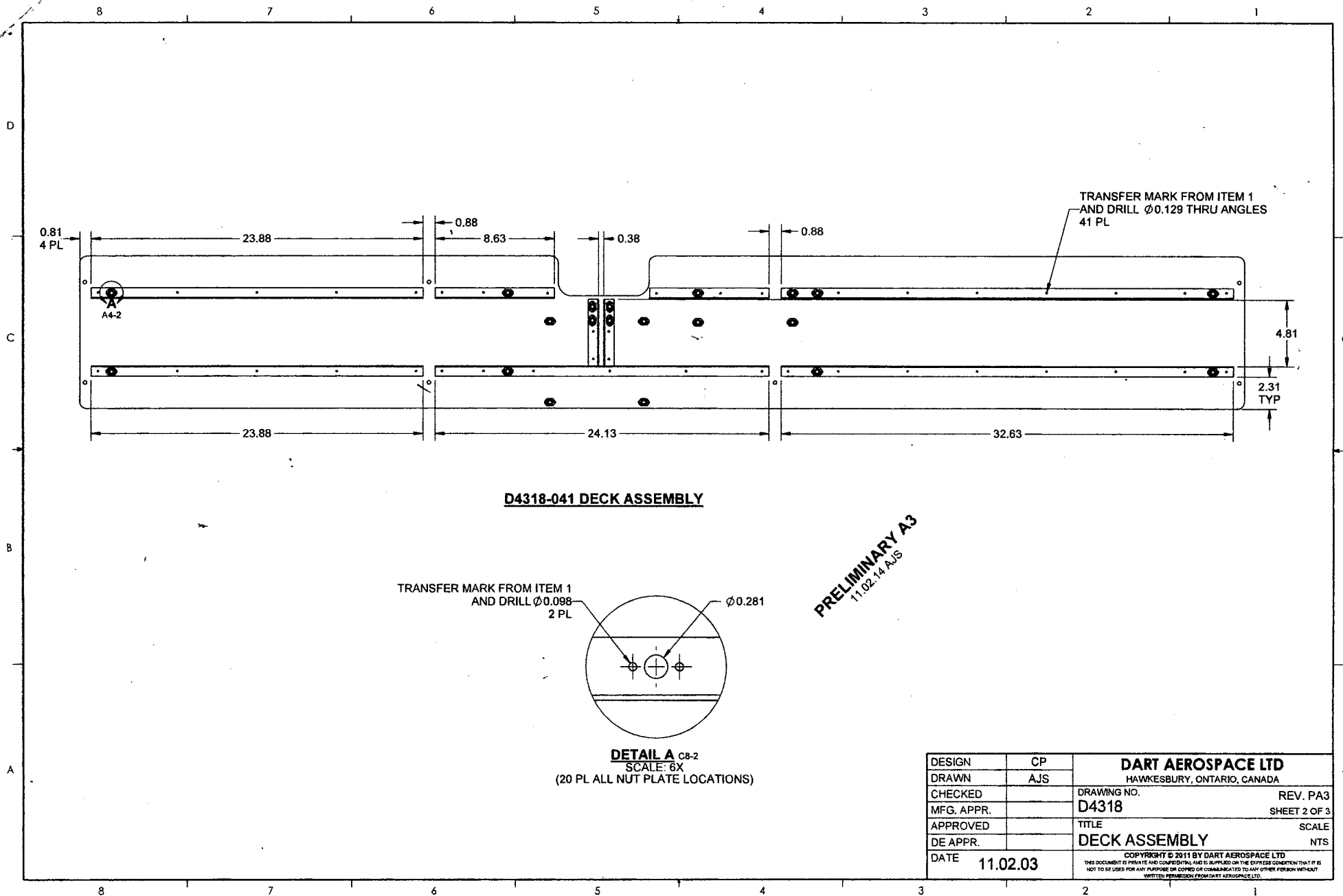
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Date:	11/22/11

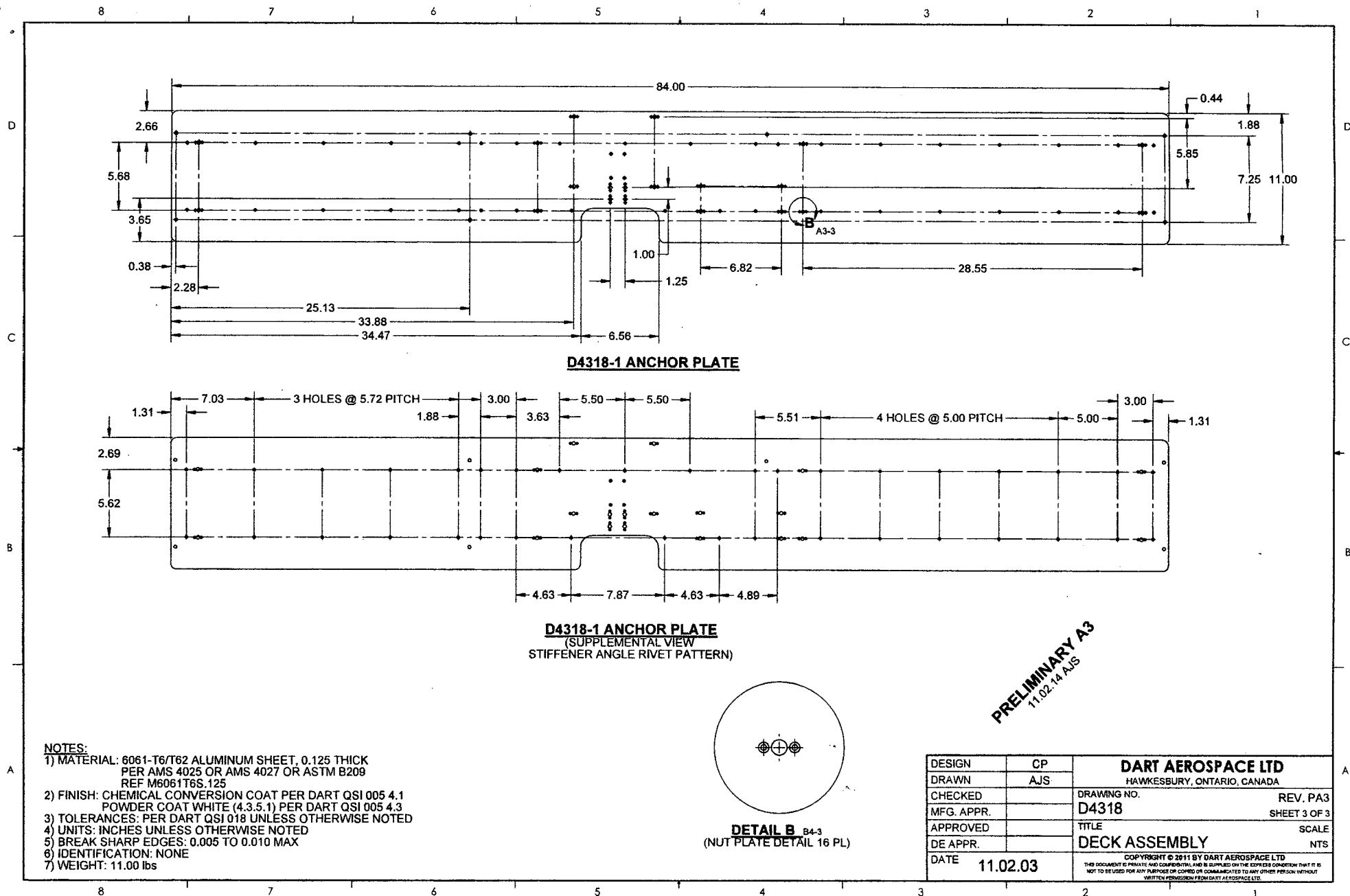
Audited by:	S
Date:	11/02/17

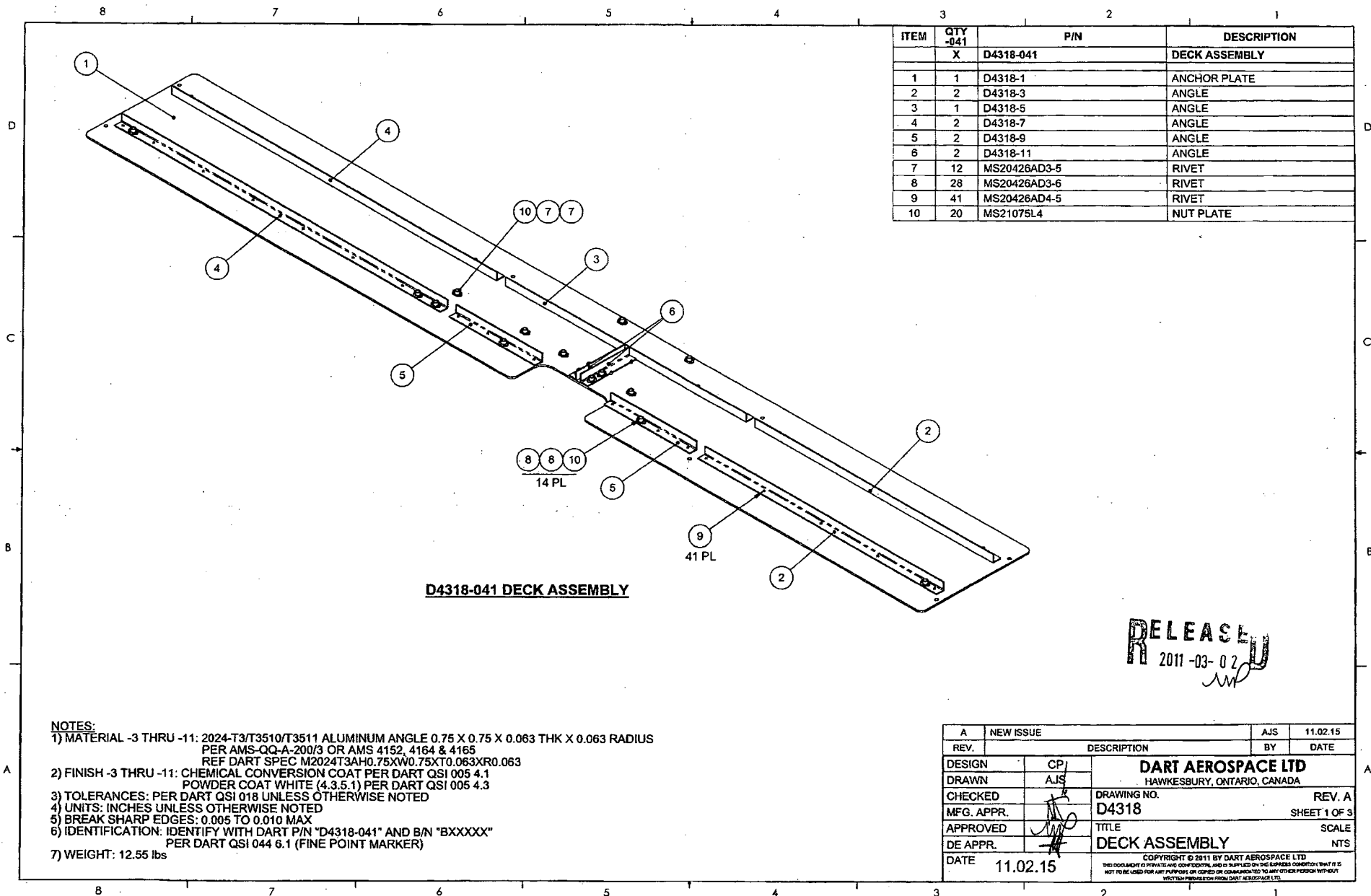
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	









ITEM	QTY -041	P/N	DESCRIPTION
	X	D4318-041	DECK ASSEMBLY
1	1	D4318-1	ANCHOR PLATE
2	2	D4318-3	ANGLE
3	1	D4318-5	ANGLE
4	2	D4318-7	ANGLE
5	2	D4318-9	ANGLE
6	2	D4318-11	ANGLE
7	12	MS20426AD3-5	RIVET
8	28	MS20426AD3-6	RIVET
9	41	MS20426AD4-5	RIVET
10	20	MS21075L4	NUT PLATE

RELEASE
2011-03-02

NOTES:

- 1) MATERIAL -3 THRU -11: 2024-T3/T3510/T3511 ALUMINUM ANGLE 0.75 X 0.75 X 0.063 THK X 0.063 RADIUS
PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3AH0.75XW0.75XT0.063XR0.063
- 2) FINISH -3 THRU -11: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4318-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 12.55 lbs

A	NEW ISSUE	AJS	11.02.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4318

TITLE
DECK ASSEMBLY

REV. A
SHEET 1 OF 3
SCALE
NTS

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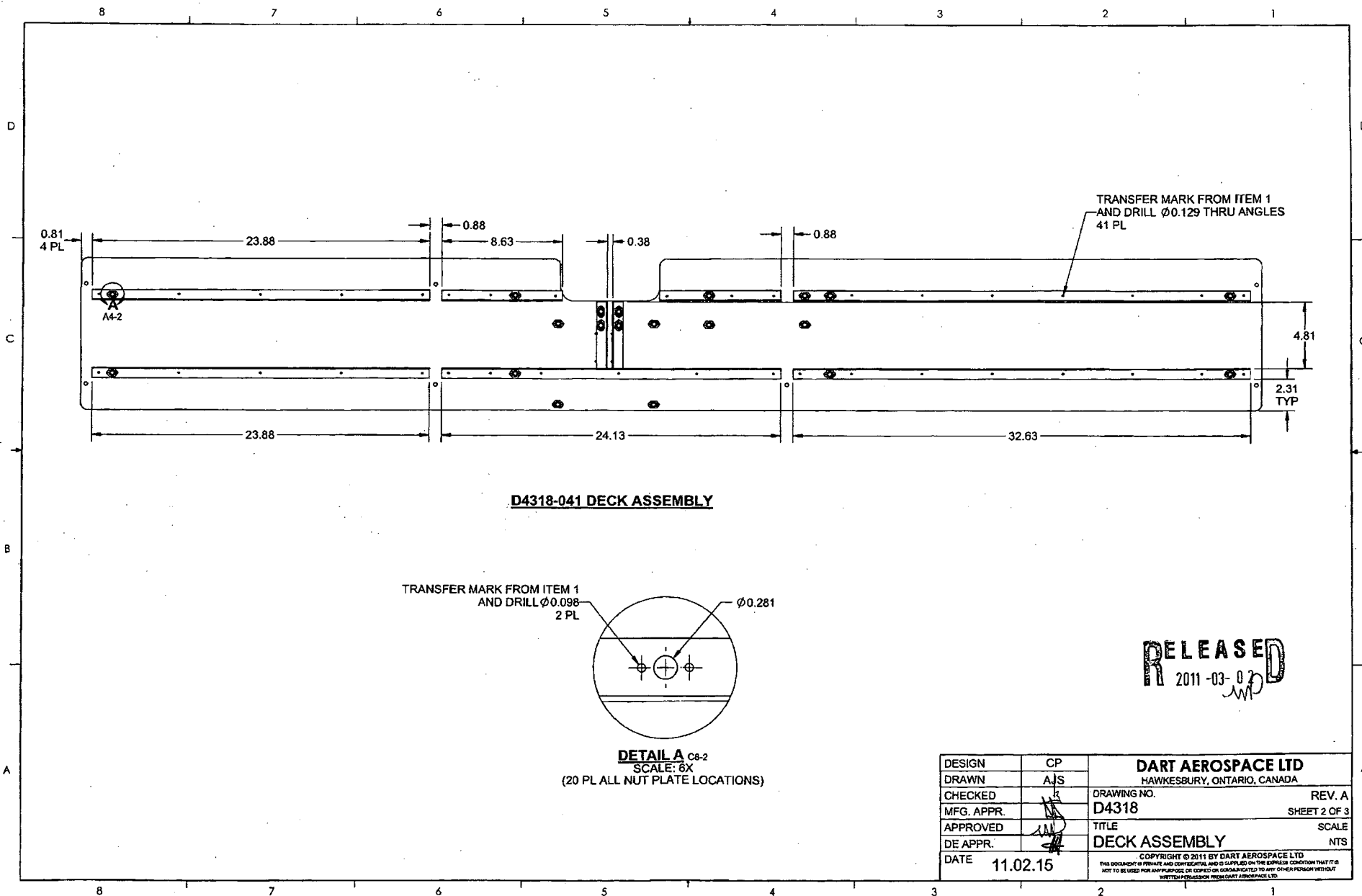
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

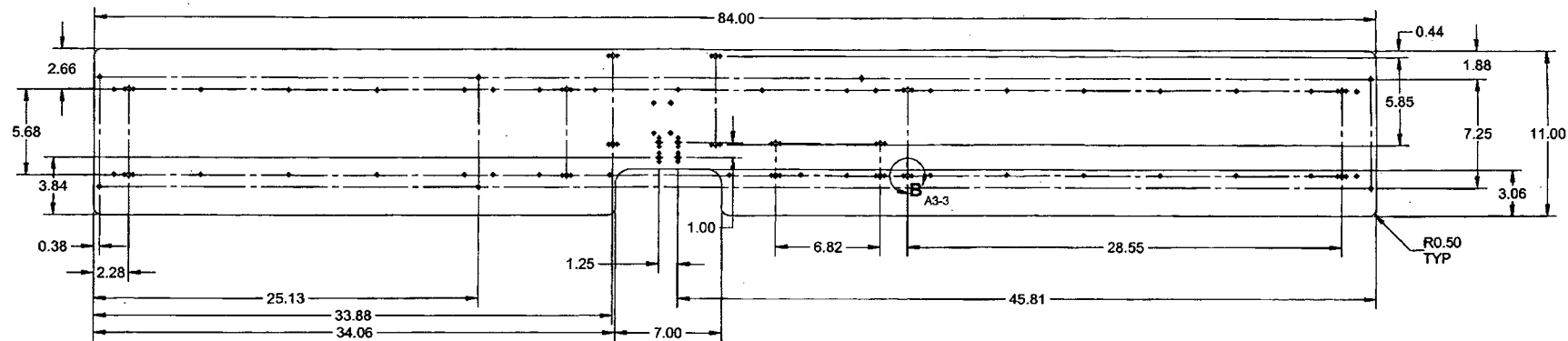
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

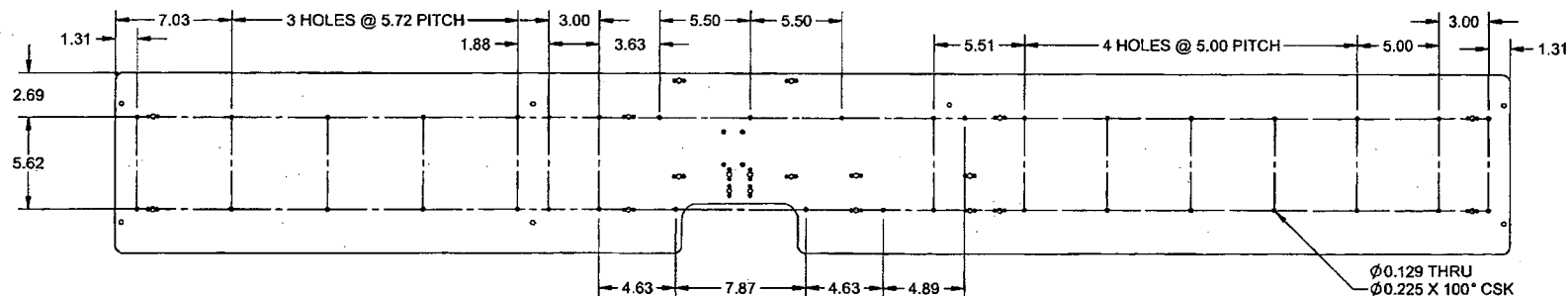
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4318-1 ANCHOR PLATE



D4318-1 ANCHOR PLATE
(SUPPLEMENTAL VIEW
STIFFENER ANGLE RIVET PATTERN)

Ø0.281

Ø0.098 THRU
Ø0.190 X 100 CSK*

DETAIL B D4-3
(NUT PLATE DETAIL 16 PL)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 11.00 lbs

RELEASED
2011-03-03

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4318	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DECK ASSEMBLY	NTS
DATE	11.02.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

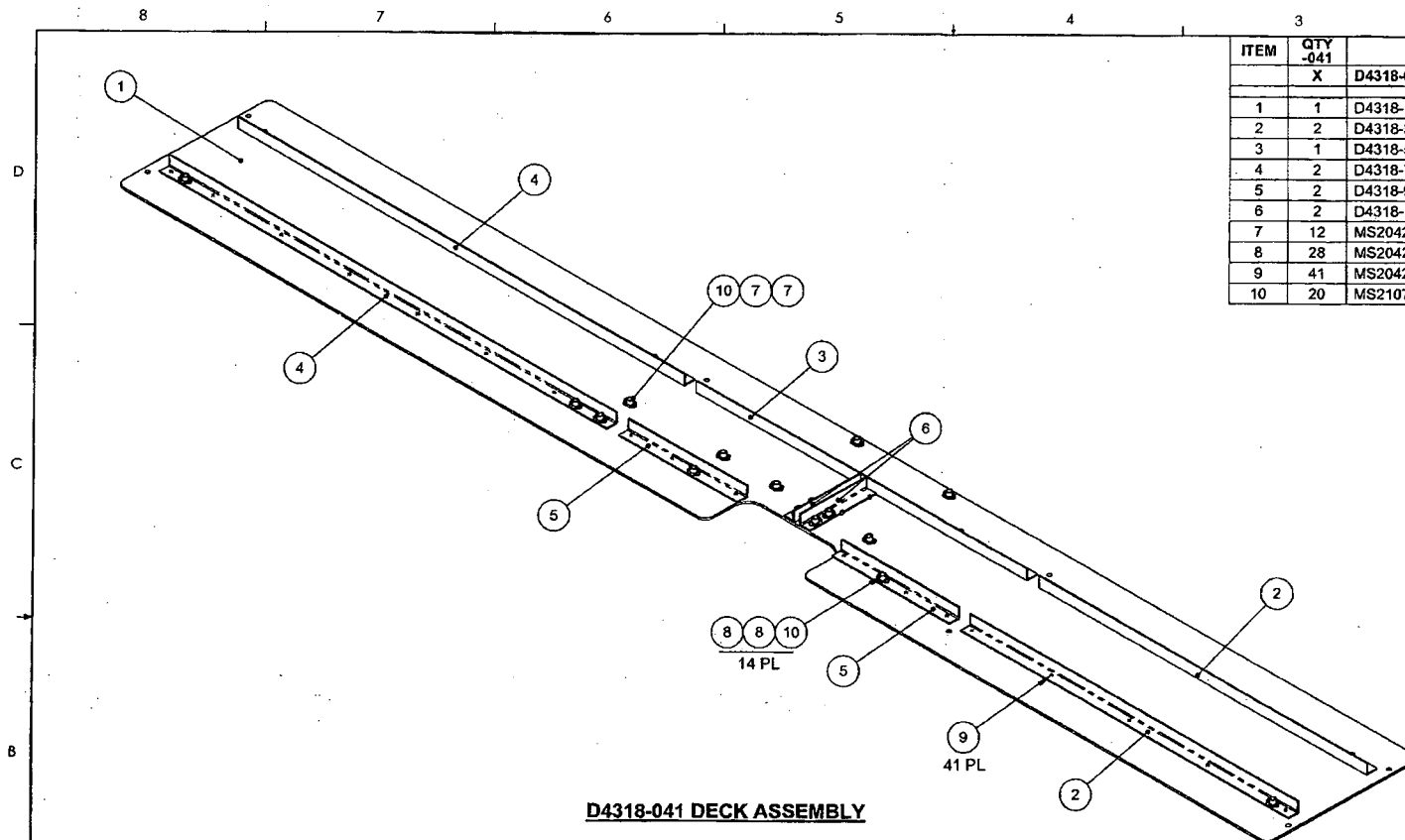
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4318-041 DECK ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4318-041	DECK ASSEMBLY
1	1	D4318-1	ANCHOR PLATE
2	2	D4318-3	ANGLE
3	1	D4318-5	ANGLE
4	2	D4318-7	ANGLE
5	2	D4318-9	ANGLE
6	2	D4318-11	ANGLE
7	12	MS20426AD3-5	RIVET
8	28	MS20426AD3-6	RIVET
9	41	MS20426AD4-5	RIVET
10	20	MS21075L4	NUT PLATE

RELEASE
2011-03-02

NOTES:

- 1) MATERIAL -3 THRU -11: 2024-T3/T3510/T3511 ALUMINUM ANGLE 0.75 X 0.75 X 0.063 THK X 0.063 RADIUS
PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3AH0.75XW0.75XT0.063XR0.063
- 2) FINISH -3 THRU -11: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4318-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 12.55 lbs

A	NEW ISSUE	AJS	11.02.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP/	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4318	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DECK ASSEMBLY	NTS
DATE	11.02.15	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

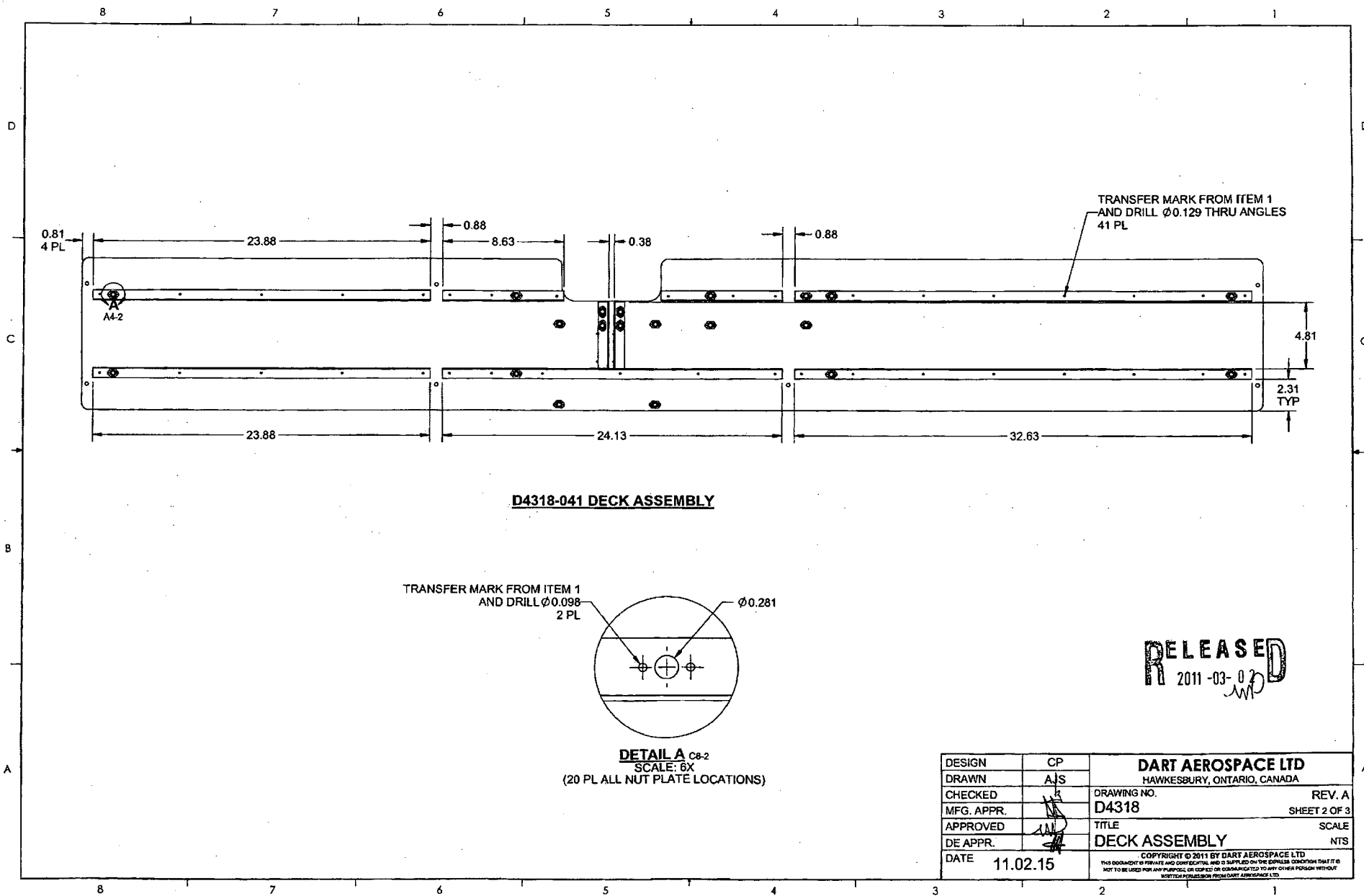
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



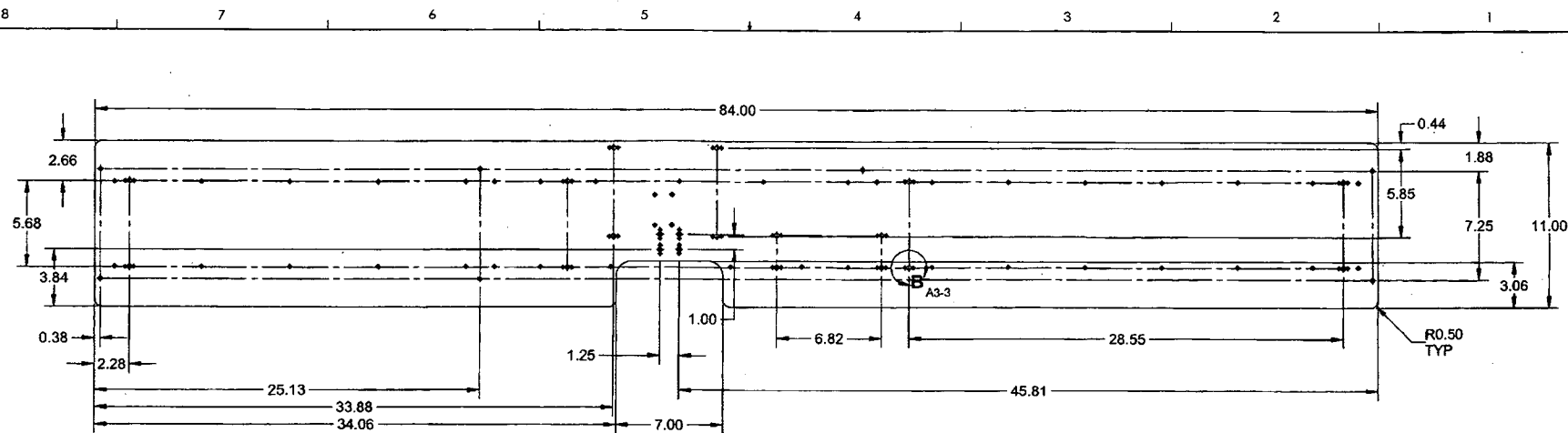
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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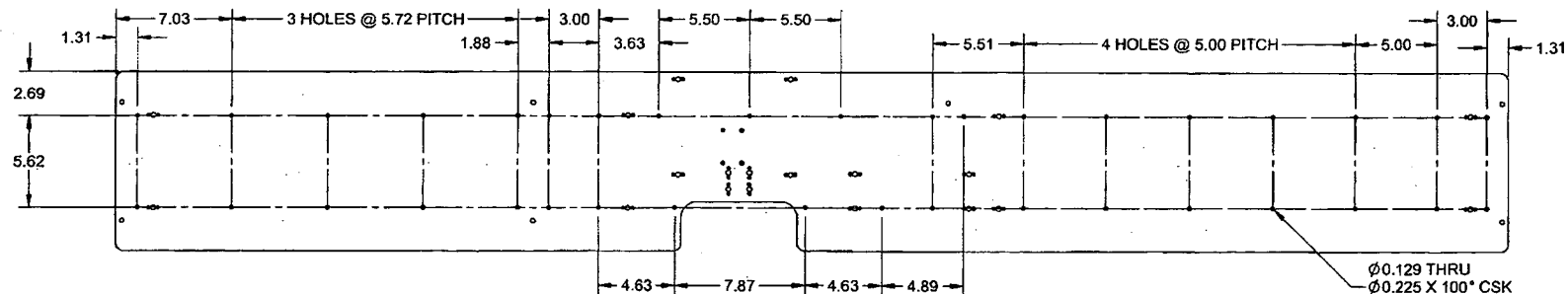
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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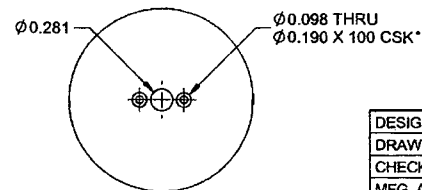
NOTE: Date & initial all entries



D4318-1 ANCHOR PLATE



D4318-1 ANCHOR PLATE
(SUPPLEMENTAL VIEW
STIFFENER ANGLE RIVET PATTERN)



DETAIL B D4-3
(NUT PLATE DETAIL 16 PL)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 11.00 lbs

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.		D4318	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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RELEASED
2011-03-03
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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